Work Order ID 51750

September 2, 2009 8:29:51 AM

Page 1

Item ID:

D2324

 \mathbf{C} **Revision ID:**

Item Name: Strut

Start Date:

9/02/09

QC:

Start Qty: 12.00

Accept

Setup Start

Stop

Required Date: 9/04/09

Reg'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_ Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/ **Work Center ID** Operation

Description

Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D2324 Rev C

100

Small Fab

Small Fab

Small Fab

Memo

Memo

Memo

Assemble as per Dwg D2324.

0.00

0.00

110

Quality Control

QC5- Inspect part completeness to step on W/O

120

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

(octorios

0.00

START TIME:

NU12260

11:30 AVBOVEN TEMPERATURE:

12: WINISH TIME:

3209=

Dart Aerospace Ltd	
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W/O:	•		\A/4	ADK ODDED CHA	NCEC	<u>.</u>	<u> </u>			
DATE	STEP	PRO	WORK ORDER CHANGES DCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·								
Part No	•	PAR #:	Fault Cate	egory:	NCR	: Yes I	No DQ	\ :	Date:	1
Resolution:			Disposition: Q			_ QA: N/C Closed: Dat				
NCR:			WORK ORD	ER NON-CONFOR	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Description	Section B on	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
-			Office Ling	One Lig		Date				
					3					

Work Order ID 51750

Page 2

September 2, 2009 8:29:51 AM

Item ID:

D2324

Revision ID: C

Item Name:

Start Date:

9/02/09

QC:

Strut

Start Qty: 12.00



Accept

Setup Start



Stop

Required Date: 9/04/09

Req'd Qty: 12.00

Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

130

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

Set Up/ **Run Hours**

SPC (Y/N):

Date:

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

Packaging

Identify as per dwg & Stock Location: 571

Packaging

150

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

0.00

Memo

0.00

/ 10 9/9/8 (12)

09/09/08/19

09-09-08

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A :	Date:	
Resolution:			Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	Sign	& Verific		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date) Geen		Office Ling	QO IIISPECIOI
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					,				
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Picklist Print

September 2, 2009 8:29:49 AM

Work Order ID: 51750

Parent Item:

D2324RevC

Parent Item Name:

Strut

Comments:

Start Date: 9/02/09

Start Qty: 12.00

Required Date: 9/04/09

Required Qty: 12.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Purchased

Bin **Primary** Item Location Last Location

Route Seq ID Unit of Measure

Qty on Hand

Remaining Qty To Pick Issued

Qty

Date Status Issued

AN3-12A

No

100

Each

63.0000 24.0000

Bolt				

		Warehouse	Lo	<u>c Oty</u>	Loc Code	
		Location				
		Main Warehouse				
		ST		63		
		106605		23		
		109297		40		
Purchased	No		100	Each	2,370.000 48	3.0000

AN960JD10

Washer

Loc Qty Warehouse Loc Code

Location Main Warehouse ST 105442

109059 109840 110985 111279 111668 112314 112369

1000

1000

Dart Aerospace Ltd

	WORK ORDER CHANGES									
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr				

Part No: _		_ PAR #:	Fault Category:	NCR: Yes No D	QA:	Date:	
	Resolution:		Disposition:	QA: N/C Closed:		Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC	Corrective Action Section B	on Section B		Approvai	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector				
	<u> </u>			. **								
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September 2, 2009 8:29:49 AM

Work Order ID: 51750

Parent Item:

D2324RevC

Parent Item Name:

Strut

Comments:



Start Date: 9/02/09

Start Qty: 12.00

Required Date: 9/04/09

Required Qty: 12.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Location Last Location Route Seq ID Unit of Measure

Qty on Hand

Remaining **Qty To Pick**

Qty Issued Date Status Issued

D2324-3RevC

Manufactured

Manufactured

No

100

Each

12.0000

12.0000

Warehouse Location

Main Warehouse

ST

51426

Loc Qty

Loc Code

12

12

D2324-5RevC

Strap

No

100

Each

35.0000 24.0000

Loc Code

Warehouse Location Main Warehouse ST

46324 47563

Loc Qty

35 34

Dart Aerospace Ltd

W/O:			WORK ORDER C	HANGES				
DATE	STEP	PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<u> </u>		
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date:	

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)	/		
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspecto
		•						
		10 mg						
					}			

Picklist Print

September 2, 2009 8:29:49 AM

Work Order ID: 51750

Parent Item:

D2324RevC

Parent Item Name: Strut



Start Date: 9/02/09

Required Date: 9/04/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Location Item

Last Location Route Seq ID Unit of

Oty on Measure Hand

Remaining Qty To Pick Issued Date Issued

Status

Page 3

MS21042L3

Comments:

Purchased

No

100

Each

3,824.000 24.0000

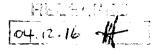
Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	3824		
110844	32		
111274	300		_24
111668	992		·
112314	2000		
112385	500		

Dart Ae	rospace	e Ltd							F:
W/O:				WORK ORDER	CHANGES				
DATE	STEP	_	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):		PAR #:	Fault Category:	NCR: Y	es No DQ	A:	Date:	
Resolution:		Disposition: QA: N/C Close			osed: Date:				
NCR:				WORK ORDER NON-CON	IFORMANCE (N	CR)			
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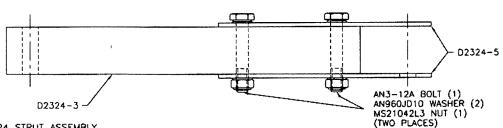
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section B			Approval			
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector		
					<u> </u>					



DESIG	N	DRAWN BY	, –	ART AEROSPACE		
ВW	ILLIAMS	PH	VI	CTORIA INTERNATIONAL AIRPORT.	CANADA	
CHEC	(ED)	APPROVED	DRAWING NO.			REV. C
	#	#	D2324		SHEET	1 OF 1
DATE		\$ () \$ ()	TITLE			SCALE
04.1	2.14		STRUT			
Α		94.11.08	NEW IS	SUE		
В		96.05.07	UPDATE	MATERIALS		
С	i	04:12.14	UPDATE	NOTES		

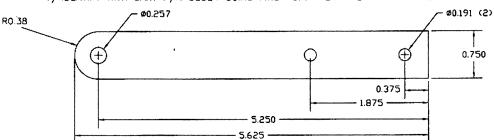


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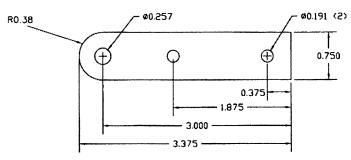
D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
 - (REF DART SPEC. M6061T680.750X00.750)
- 2) FINISH:
- ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dan Ae	ospace	ELU								
W/O:			WO	RK ORDER CH	ANGES		*****			
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NC	R: Yes N	lo DQ	۸:	_ Date: _	
	R	esolution:	Disposition	ı:	QA	: N/C Clo	sed:		Date:	
NCR:		V	VORK ORDE	R NON-CONFO	ORMANCI	E (NCR)				
		Description of NC		Corrective Action	Section B	· · · · · · · · · · · · · · · · · · ·	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descri		Sign & Date	Section	1	Chief Eng	QC Inspector

		Description of NC		Corrective Action Section B				
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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